

Work Order ID 79301

79301

Page 1

January-24-12 1:55:45 PM

Item ID: D4450-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 24/01/2012 Start Qty: ~~6.00~~ ¹⁰ ***6*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4450	A								

100 Small Fab ^{6 + 3} 0.00
100
 Small Fab Memo cut at 27" 0.00 SP FF 02-01-25 10
 Small Fab 1- punch one side
 2- bend as per dwg
 3- drill holes as per dwg
 4- deburr

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00 Srborlog (H0)
 Quality Control

120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
120
 Powdercoat Memo 3-30 0.00
 Powder Coating START TIME: 4:00 OVEN TEMPERATURE: 320:05
 FINISH TIME: 4:10
W115128 10X M/L 12/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79301***79301***

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January-24-12 1:55:45 PM

Item ID: D4450-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 24/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 07/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00

130

QC Memo

0.00

Quality Control

10 12/2/15

140 Identify as per dwg & Stock Location 229

0.00

140

Packaging Memo

0.00

Packaging

12/2/16 (10)

150 QC21- Final Inspection - Work Order Release

0.00

150

QC Memo

0.00

Quality Control

M.L.J. 12/02/16

M.L.J.
12/02/16
(10)

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NOTE: Date & initial all entries

Picklist Print

January-24-12 1:55:48 PM

Page 1

Work Order ID: 79301

79301

Parent Item: D4450-1

D4450-1

Parent Item Name: Arm

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.14 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	209.3131	2.3	14.52632			

M304TR0 500W 049

304 RD Tube .500 x .049W

**

Location	Loc Qty	Loc Code
MAT017	209.313058	
111814	2.23	
115010	109.254058	
117598	42.57	
119087	55.259	

3.10
15
12-01-25
12-01-25

W/O:		WORK ORDER CHANGES					
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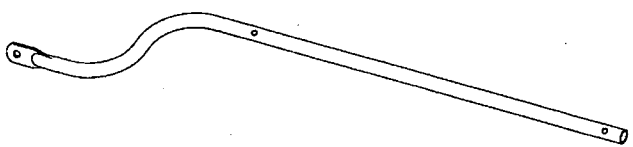
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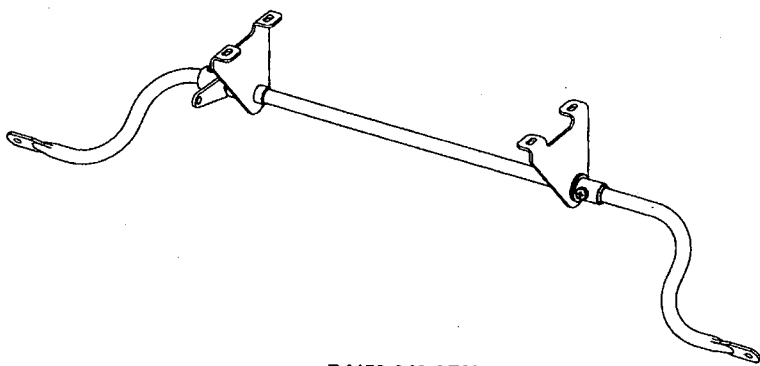
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4450-1 ARM



D4450-043 ARM

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 REFERS TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

79301 M.L.J
 12/01/24

RELEASED
 2011-11-10
 JND

A	NEW ISSUE	MB	11.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4450 TITLE ARM SCALE NTS	REV. A	SHEET 1 OF 4
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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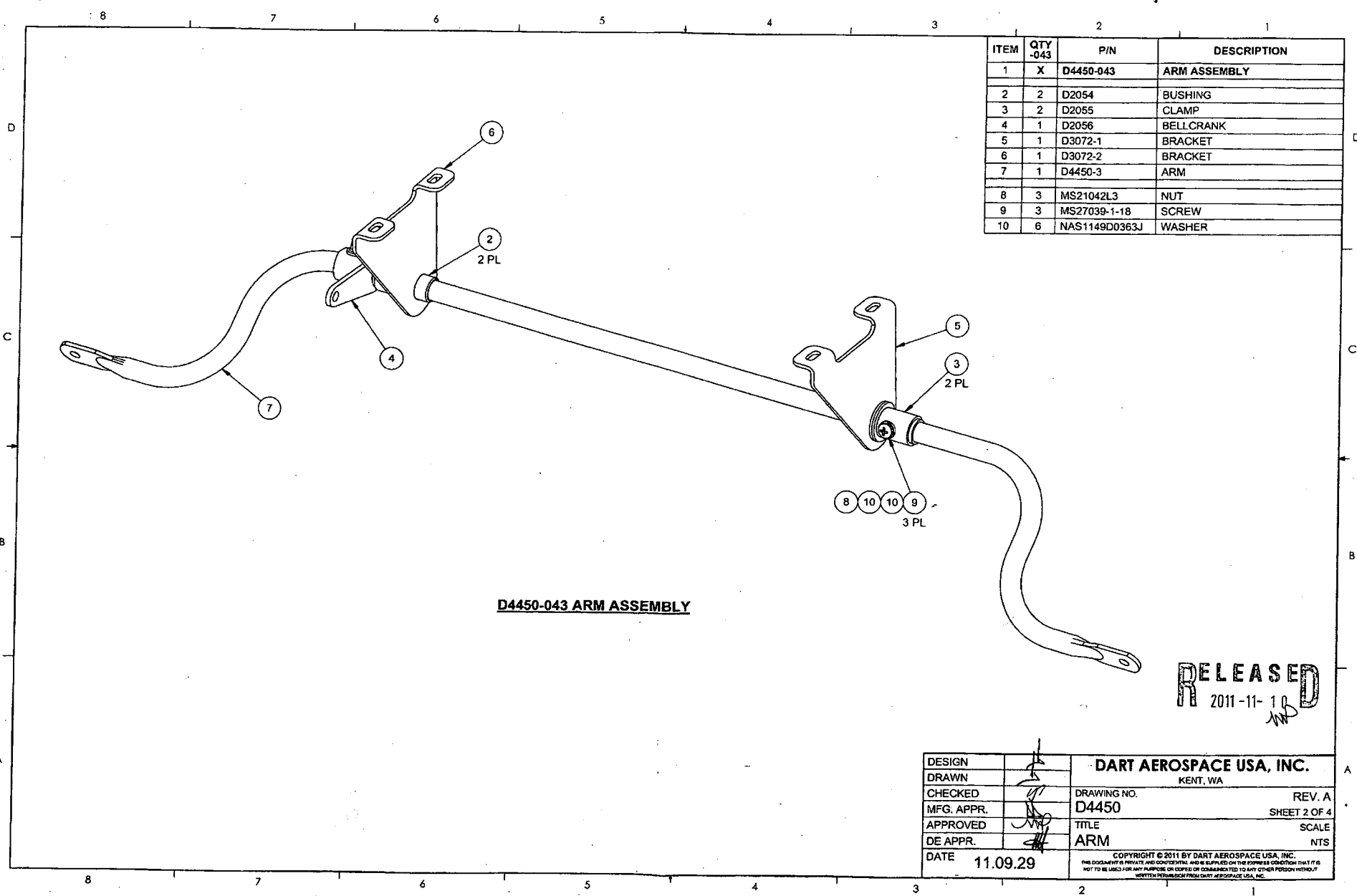
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79301



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4450-043	ARM ASSEMBLY
2	2	D2054	BUSHING
3	2	D2055	CLAMP
4	1	D2056	BELL CRANK
5	1	D3072-1	BRACKET
6	1	D3072-2	BRACKET
7	1	D4450-3	ARM
8	3	MS21042L3	NUT
9	3	MS27039-1-18	SCREW
10	6	NAS1149D0363J	WASHER

D4450-043 ARM ASSEMBLY

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DE APPR.		ARM	NTS
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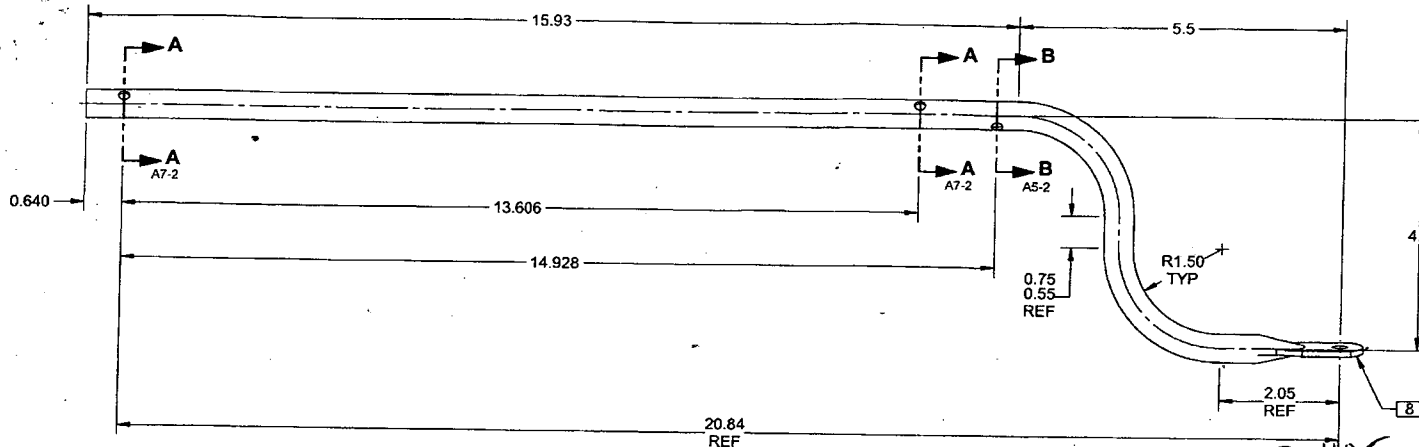
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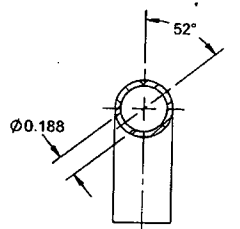
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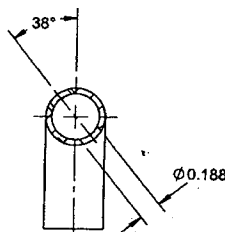
21.815 T.L.



D4450-1 ARM



SECTION A-A
SCALE 2X C4-2 C8-2



SECTION B-B
SCALE 2X C4-2

D4450-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.50 \times 0.049$ WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) PUNCH END PER SPEC. CONTROL DRAWING D2727

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2011-11-18

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D4450	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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W/O:		WORK ORDER CHANGES					
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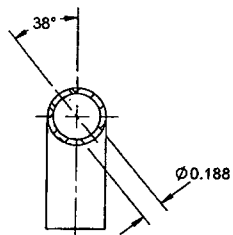
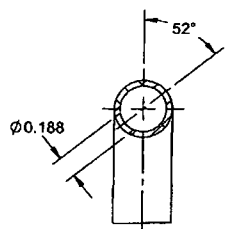
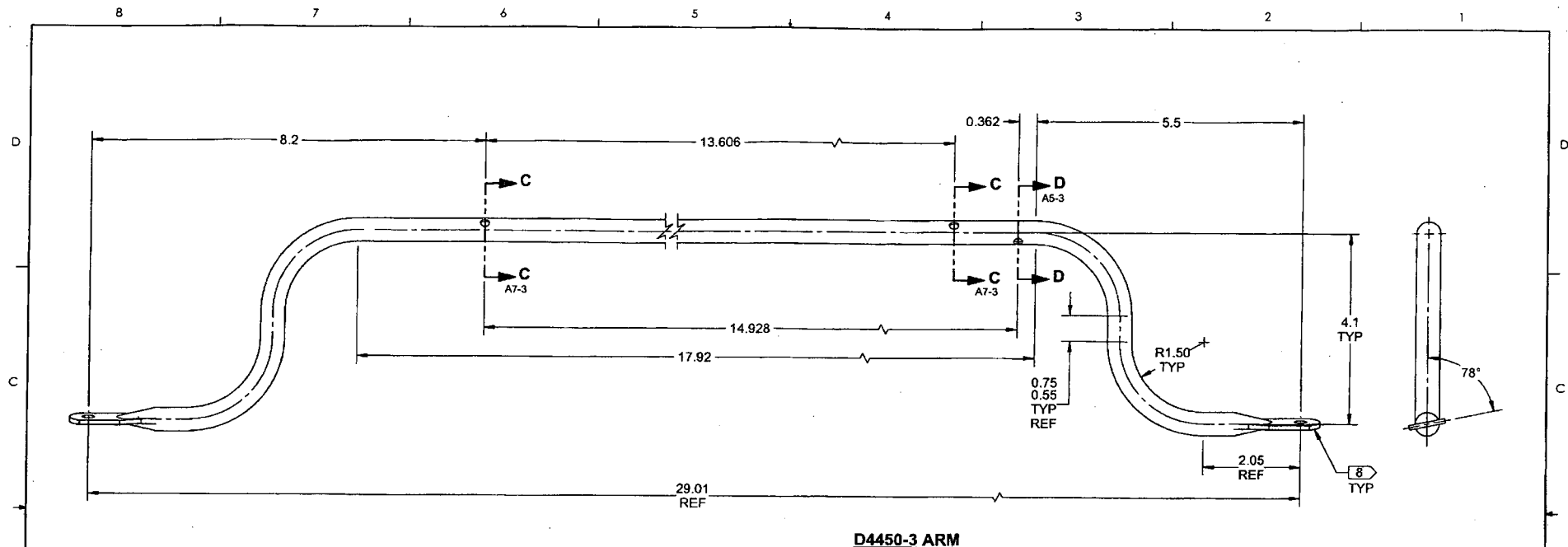
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

79301



D4450-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.50 \times 0.049$ WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION NONE
- 7) WEIGHT: 0.72 lbs
- 8) PUNCH END PER SPEC. CONTROL DRAWING D2727
- 9) REFER TO SHEET 2, D4450-043 ARM ASSEMBLY, FOR INSTALLATION OF REQUIRED PARTS PRIOR TO PERFORMING ALL BENDS

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2011-11-10

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4450	SHEET 4 OF 4
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